

DEPU 54565

Work Order ID 53906



Page 1

November 23, 2009 2:39:31 PM

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 23/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: PA

Date: 09-11-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

N/A

(X)

MP

09-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 - - Aug 8-12-01

① / 0 BE 09-12-01

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

M112507

BE 09/12/01

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

M112507

BE 09/12/01

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aff cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Towing using DT8091, open to .640" and Deburr

AWM 9-12-02

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	⇒ S on 12/04						
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ S on 12/04						
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	bf 09-12-7						

W/O:		WORK ORDER CHANGES					
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Stop



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>in 11/21/48</i> Memo START TIME: <u>9:15</u> OVEN TEMPERATURE: <u>350</u> FINISH TIME: <u>9:45</u>	0.00 0.00							
				<i>BR 09-12-7</i>		<i>①</i>			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>=> 11 09/12/07</i>		<i>①</i>			

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Stop



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200

0.00



HandFinish

Memo

0.00

Hand Finishing

2/11/09/12/09

VI 8

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112315 ☐ ☐ ☐
Sikaflex expire date: 10/18

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112345 ☐ ☐ ☐
Sikaflex expire date: 10/09

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 11112623

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Run Start



Stop



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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00							
220 	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____	0.00							
230 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

278 on 12/07

(70)

PPPS1227 10-9/14/8

09/12/08

W 09.12.08

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Picklist Print

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Page 1

Work Order ID: 53906



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2580-1RevD

Manufactured

No

110

Each

1.0000

1.0000



205 Skidtube bent detail

B-53539 MS 09-11-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

53233

1

140

Each

160.0000

1.0000

D2576-3RevG

Manufactured

No



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

160

43504

12

46661

101

52215

47

1 BG 09/12/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2579RevE		Manufactured	No			140	Each	193.0000	20.0000			
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Crossbolt Spacer

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	LG	71	
	51525	71	
Main Warehouse	ST	122	
	43988	4	
	46434	4	
	46956	2	
	47797	9	
	48272	2	
	51314	71	
	51315	30	

20 BC 09/12/01

D2855RevA

Manufactured No



Cap

200	Each	92.0000	1.0000
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Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	FP6	92	
	50513	1	
	50770	3	
	51539	88	

Y1 24 09/12/07

W/O:		WORK ORDER CHANGES					
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Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN3-5A		Purchased	No			200	Each	2,171.000	2.0000			
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Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2171	
100188	188	
105057	1983	

x2 H/ 09/12/07

AN960JD10L		Purchased	No			200	Each	5,592.000	2.0000			
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Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5592	
101291	16	
104885	153	
105793	236	
109632	348	
110985	4839	

x2 H/ 09/12/07

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bia- Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	--------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS7-1032-130		Purchased	No			200	Each	2,880.000	50.0000			
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Insert

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2880	
105855	16	
108606	52	
111529	1488	
111779	313	
112772	11	
113238	1000	

x50 09/12/07

AN3C4A		Purchased	No			200	Each	2,075.000	50.0000			
--------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



BOLT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2075	
112314	13	
112720	12	
112724	3	
112829	88	
112991	39	
113121	920	
113226	1000	

y50 09/12/07

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AN960C10L		Purchased	No			200	Each	2,604.000	50.0000			
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washer

Warehouse	Location	Loc Qty	Loc Code
OFFSHORE			
	FG	100	
	103585	100	
Main Warehouse			
	ST	2504	
	112116	548	
	112612	956	
	112933	1000	

D3566-13RevC

Manufactured No

200 Each 106.0000 1.0000



Gasket

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse			
	FP	104	
	51606	21	
	53461	83	
Main Warehouse			
	ST	2	
	45717	1	
	50265	1	

XSD 21 09/12/07

X1 21 09/12/07

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Shop Packet Print

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D3566-5RevC		Manufactured	No			200	Each	48.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	28	
51929	2	
53804	26	
Main Warehouse		
FP19	16	
52909	16	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

✓ 11/09/12/09

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D3566-1RevC		Manufactured	No			200	Each	65.0000	2.0000			
												

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	36	
52512	3	
53790	33	
Main Warehouse		
ST	29	
46349	1	
51218	1	
51259	3	
53455	24	

xl 14/02/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:39:38 PM

Work Order ID: 53906



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-11RevD

Manufactured

No

200

Each

33.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

1353808

Y1 09/12/09

Main Warehouse

FP

5

51905

5

Main Warehouse

FP19

26

51594

3

52125

23

Main Warehouse

ST

2

45823

1

50112

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:39:38 PM

Work Order ID: 53906



Parent Item: D205-634-041RevD



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Start Date: 23/11/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-13RevD

Manufactured

No

200

Each

46.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP17

34

51611

32

52059

2

Main Warehouse

ST

12

45409

2

46495

10

x1 Hl 09/12/07

D3564-9RevD

Manufactured

No

200

Each

21.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

19

51675

1

52593

18

Main Warehouse

ST

2

44659

1

45825

1

x1 Hl 09/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:39:38 PM

Work Order ID: 53906



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-5RevD

Manufactured

No

200

Each

24.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

7

51925

7

Main Warehouse

ST

15

45824

1

47433

1

52595

13

D2594-3RevC

Manufactured

No

200

Each

840.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

27

51613

27

Main Warehouse

ST

813

52562

813

X1 M 09/12/09

X16 M 09/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:39:38 PM

Work Order ID: 53906



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	431.0000	16.0000			
Plug, 205 Skidtube												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	431	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	309	

x 16 41 09/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMEND
WITHOUT NOT
WORK OR
NO. 53906
07/09/11-23

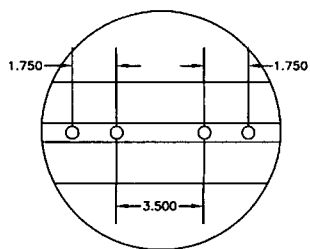
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

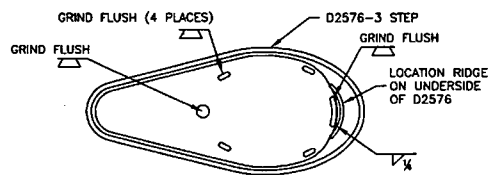
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DETAIL E
SCALE 5:24

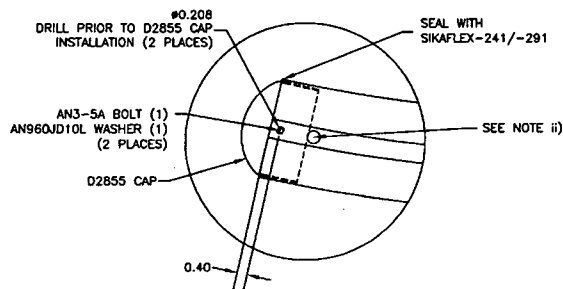


DETAIL F
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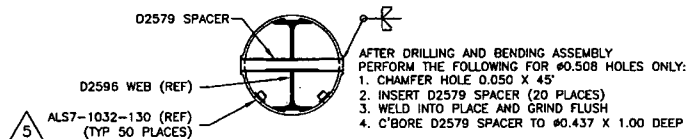


RELEASED
07 Dec 84

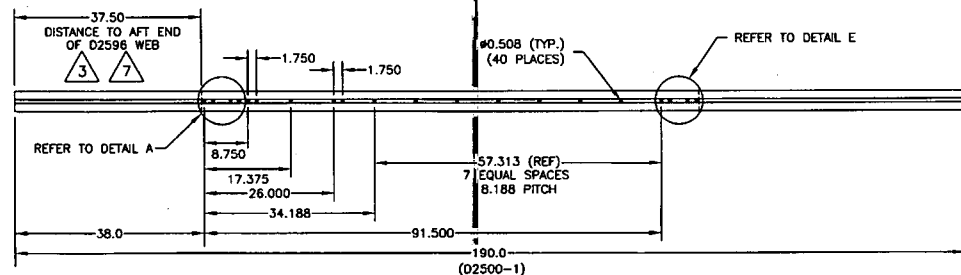
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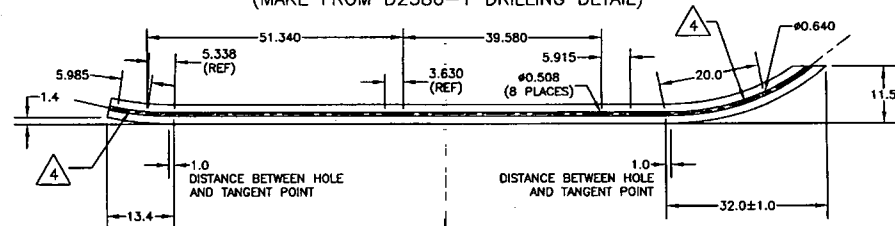
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SCALE 5:24



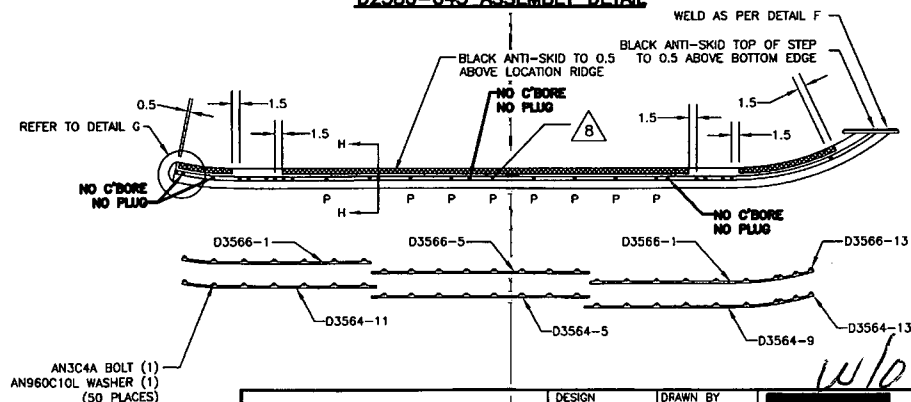
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. MARKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W1053906

NO. 219

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 53918
Part number: D205-634-041
Description: 205 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pet. Durb Date of Test Coupon 09.12.04
Welder Barclay Elliott Date of Test Coupon 09.12.04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld